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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9186	REV. A SHEET 1 OF 3
DATE 00.05.05		TITLE SPACEPOD LATCH MODIFICATION	SCALE NTS
A	00.05.05	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWING: D350-600 REV. A OR REV. B

REF. CANADIAN STC: SH93-88
US FAA STC: SR00098NY
SR00099NY

INTRODUCTION

THE PURPOSE OF THE DSI 9186-011 KIT IS TO PROVIDE THE HARDWARE TO REPLACE THE EXISTING D2443 LATCHES (REF. HARTWELL PART NUMBERS H605S190A496 OR H2818-3S125A OR H605K3240) WITH D2586 LATCHES. NOTE THAT WHEN LATCHES ARE CHANGED, THE D2982-041 PROP ARM ASSEMBLY REPLACES THE EXISTING PROP ARM ASSEMBLY.

PART LIST

Qty -011	Part Number	Description
X	DSI 9186-011	LATCH MODIFICATION KIT
2	D2464-0025	NEOPRENE SEAL
2	D2586	LATCH
1	D2589	KEYS, KEY CHAIN
4	D2621	LATCH PLATE
1	D2982-041	PROP ARM ASSEMBLY
2	AN960JD10	WASHER
2	MS21042L3	NUT (OR MS21042-3)
2	MS27039-1-25	SCREW

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9186	REV. A SHEET 2 OF 3
DATE 00.05.05		TITLE SPACEPOD LATCH MODIFICATION	SCALE NTS

PROCEDURE:

AT EACH LATCH LOCATION

1. REMOVE EXISTING D2443 LATCH AND D2145 LATCH BRACKET FROM THE DOOR.
2. REMOVE 2.5" (MAX) OF SEAL FROM EDGE OF THE DOOR PER FIGURE 1.
3. DRAW A LINE CONNECTING THE CENTRES OF THE TWO LARGE HOLES FOR THE EXISTING LATCHES.
4. LINE UP THE INSIDE EDGE OF D2621 LATCH PLATE WITH THE EDGE OF LARGER LATCH HOLE AS SHOWN IN FIGURE 1. MAKE SURE THE D2621 LATCH PLATE IS CENTERED ON THE LINE CREATED AT STEP 3.
5. USING THE D2621 LATCH PLATE AS A TEMPLATE, MARK THE CUTOUT PROFILE FOR THE LATCH.
6. CUT A HOLE IN THE DOOR PER THE PROFILE CREATED AT STEP 5. TRIM TO FIT D2586 LATCH.
7. CLEAN THE INSIDE AND OUTSIDE OF THE DOOR IN THE VICINITY OF THE D2621 LATCH PLATE WITH ACETONE.
8. INSTALL D2621 LATCH PLATES ON BOTH THE INSIDE AND OUTSIDE OF THE DOOR AS SHOWN IN SECTION A-A USING 5 MIN. EPOXY OR PRC. ENSURE THAT THE LATCH PLATES LINE UP WITH THE RECTANGULAR CUTOUT FOR THE D2586 LATCHES. CLAMP LATCH PLATES IN PLACE. FILL THE VOID BETWEEN THE D2621 LATCH PLATES AS SHOWN IN FIGURE 1 WITH 5 MIN. EPOXY OR PRC. WIPE AWAY EXCESS EPOXY OR PRC FROM ALL AROUND THE LATCH PLATE INSTALLATION. ALLOW AT LEAST 15 MIN. BEFORE REMOVING CLAMPS AND PROCEEDING TO THE NEXT STEP.
9. INSTALL REPLACEMENT D2464-0025 NEOPRENE SEAL OVER THE D2621 LATCH PLATE.
10. INSTALL D2586 LATCH AND D2982-041 PROP ARM ASSEMBLY PER FIGURE 2 AND 3.

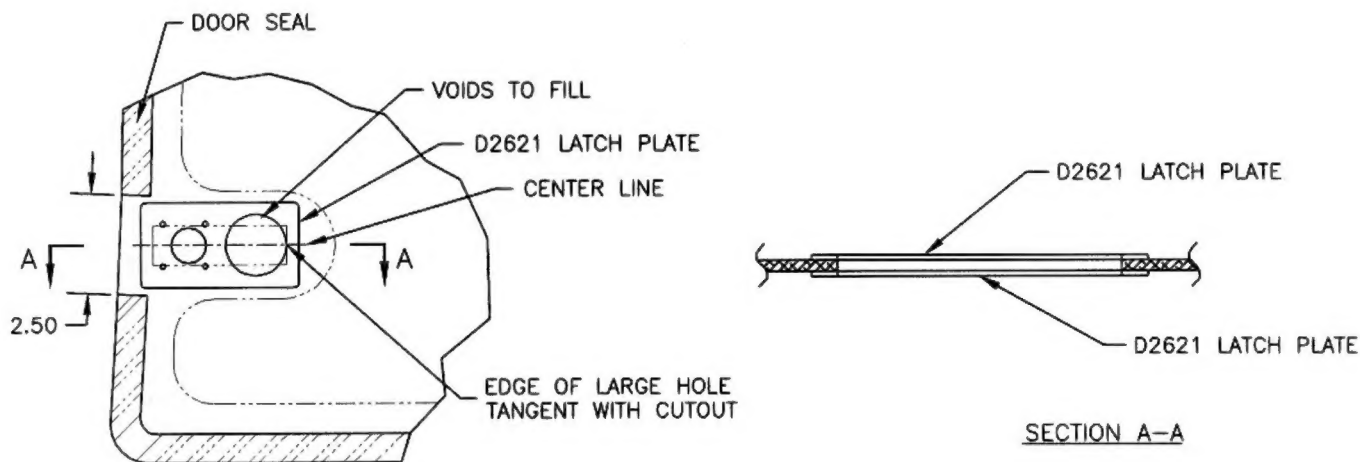


FIGURE 1: TYPICAL DOOR CUTOUT

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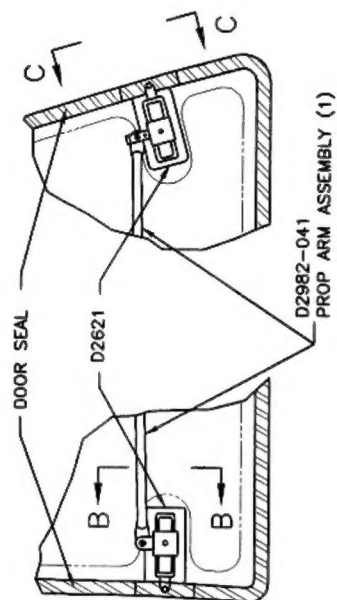


FIGURE 3: SPACEPOD DOOR

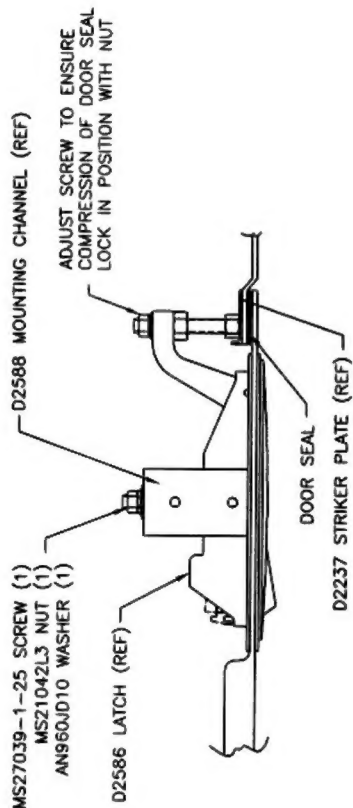
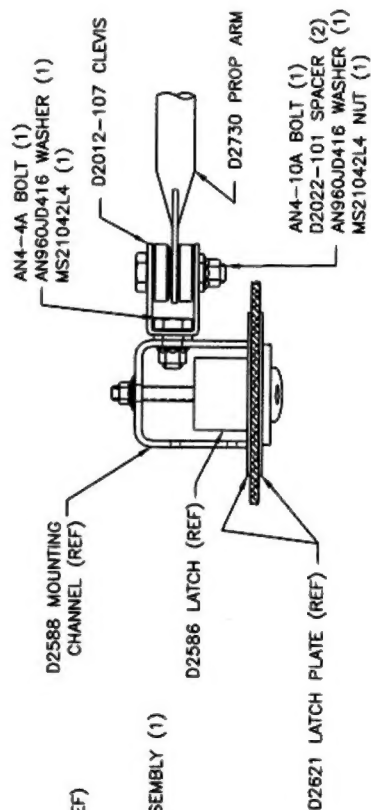
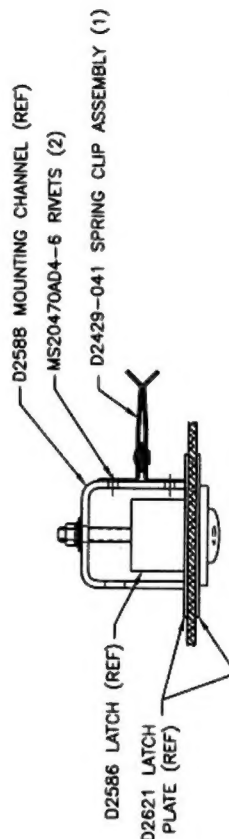


FIGURE 2: TYPICAL LATCH INSTALLATION



SECTION B-B
AFT LATCH

(REFERENCE ONLY FOR REPLACEMENT PARTS)



SECTION C-C
FWD LATCH

(REFERENCE ONLY FOR REPLACEMENT PARTS)

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